

Split

Need to slip

Oct. 24

Work Order ID 75207-1

75207

Item ID: D3199-4 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket, Fwd RH
Start Date: 18/10/2011 Start Qty: 90.00 *90* Cust Item ID:
Required Date: 04/11/2011 Req'd Qty: 90.00 *90* Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/10/18 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3199	E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3199								
	Dwg Rev: E								
	Prog Rev: E								
	Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B11-10-19

(136)

B11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75207

75207

Page 2

Item ID: D3199-4

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket, Fwd RH

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

8/11/25

SP 11/10/25

8/11/25

counts
(x136)
QSP015

(90)

counts
(x90)
QSP015

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Work Order ID 75207

75207

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October-18-11 4:11:27 PM

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 Item Name: Bracket, Fwd RH
 Start Date: 18/10/2011 Start Qty: 90.00 ***90*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 90.00 ***90*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 1240								
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 220								
160	QC3- Inspect Part Finish	0.00							
160									
QC		0.00							
Quality Control	Memo								
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging		0.00							
Packaging	Memo								

90X8 M-L 11/10/26

90. BL 11-10-26

11/10/26 928

M 118489

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75207***75207***

Page 4

Item ID: D3199-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

11/10/26 AG

MK
11-10-26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

October-18-11 4:11:32 PM

Page 1

Work Order ID: 75207

75207

Parent Item: D3199-4

D3199-4

Parent Item Name: Bracket, Fwd RH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

Comments: IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.1673	15.84947	23.		

M304S20GA

304/316 .040 Sheet

**

1811-10-18

Location

Loc Qty

Loc Code

MAT020

137.0795

116623

0.2

117550

8.363

117933

43.3442

118400

25.6723

118964

59.5

~~117933~~

118964

(136)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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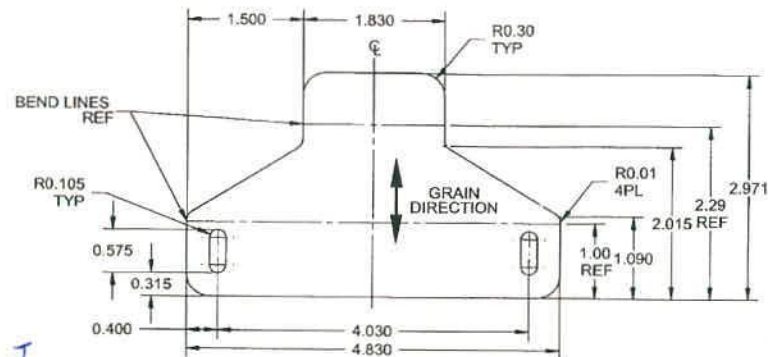
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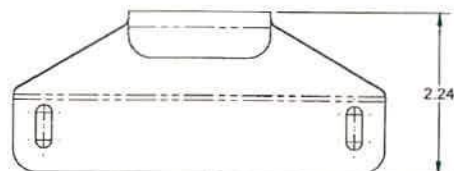
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75207 M.L.J

11/10/18



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDETEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

RELEASED
2011-07-18
MP

E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	h		
CHECKED	h		
MFG. APPR.	h		
APPROVED	h		
DE APPR.	h		
DATE	11.07.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3199	REV. E
TITLE BRACKET	SHEET 1 OF 4
SCALE NTS	
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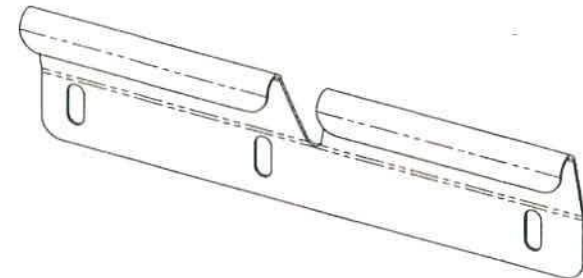
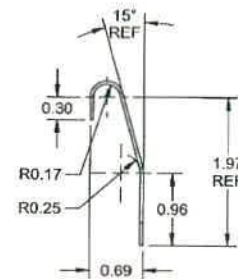
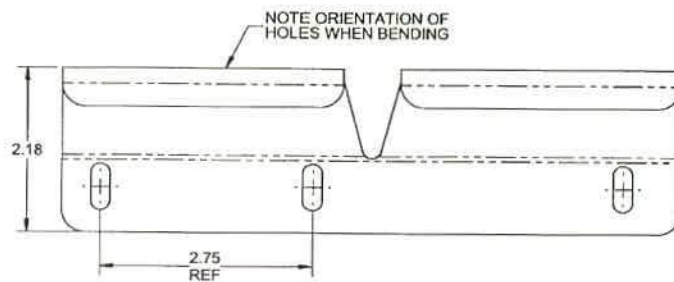
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NOTE: Date & initial all entries

75207



D3199-3 BRACKET
MADE FROM D3199-3F

RELEASED
2011-07-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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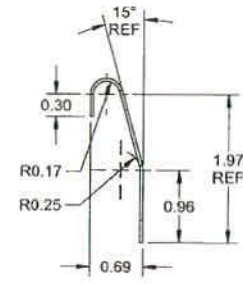
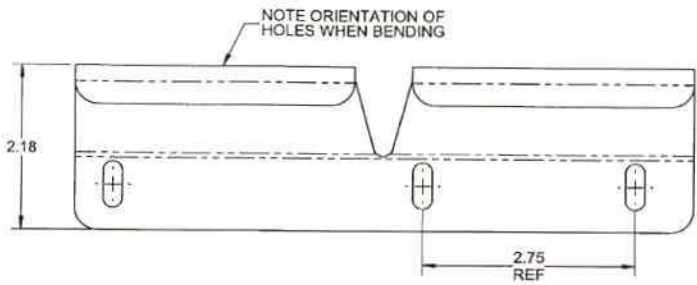
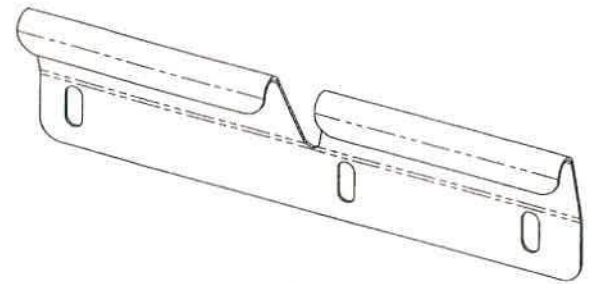
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NOTE: Date & initial all entries

75207



D3199-4 BRACKET
MADE FROM D3199-3F

RELEASED
2011-07-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.11	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

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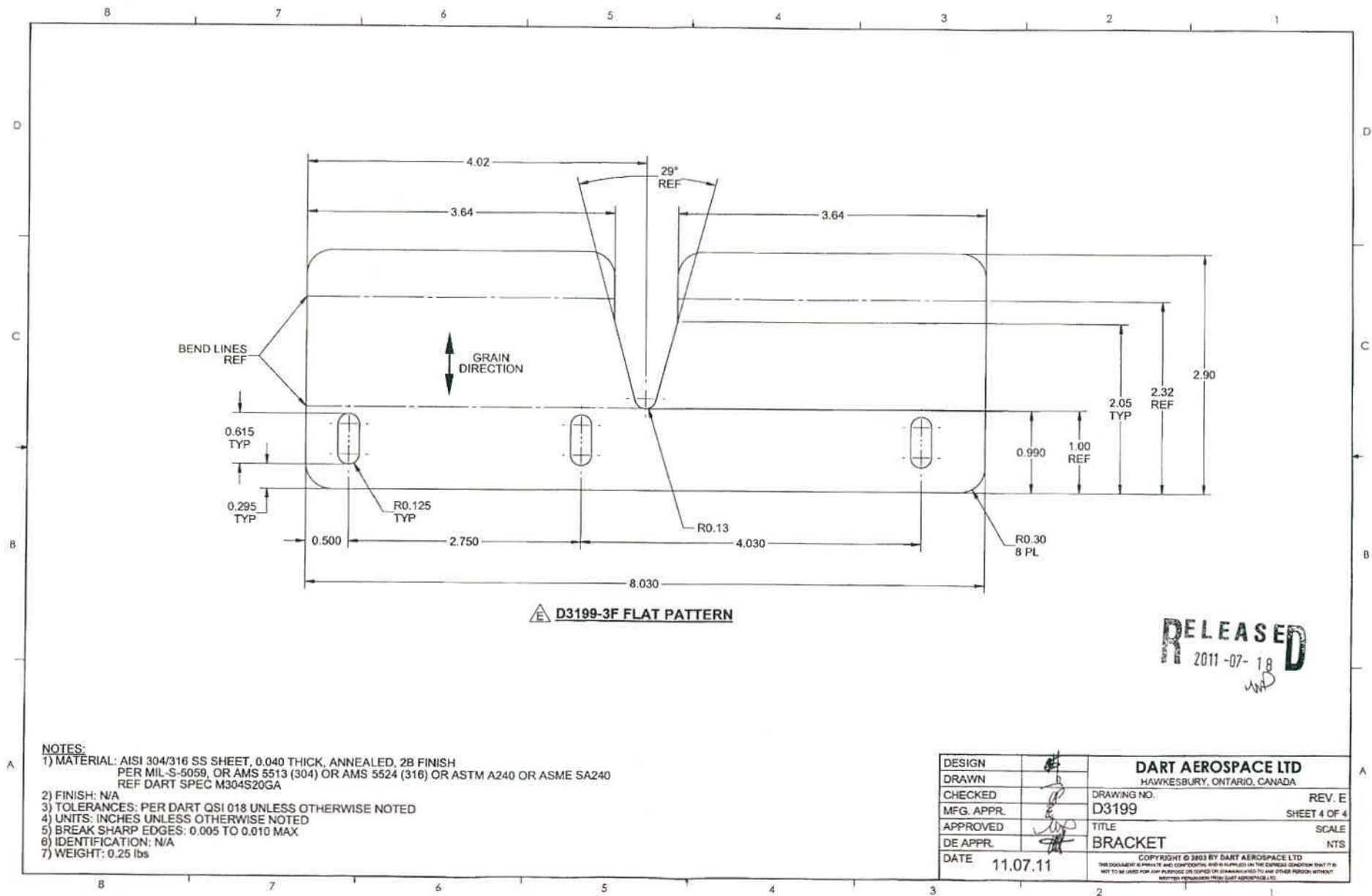
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Work Order:

Part Number: D3/64-2

Page 1 of 1

X



Prototype

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

Date:

FORMS: Quality Assurance approved QAF# rev D

W/O:		WORK ORDER CHANGES					
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